

# Work Order ID 51814

September 3, 2009 2:32:34 PM



Page 1

Item ID:	D3172-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Basket Base Assembly					
Start Date:	09/04/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	09/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09-09-03</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3172	Rev C

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut Qty 4 D3166-1 as per Dwg D3172 □ 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 □ 3-Drill holes in D3172-3 as per Dwg D3172 □ 4-Debur & Remove all markings from material □ 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Debur as r								

LD 09.09.09.  
CPC 09.09.14

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

109/09/14

120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

=> 509/09/14

ⓧ φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Item ID: D3172-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Base Assembly

Start Date: 09/04/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

M112268 \* pressure wash

⇒ 1st 09/09/15 (X) C

Powder Coating

1ST COAT: START TIME:

7:00 PM

OVEN TEMPERATURE:

7:30 PM FINISH TIME:

400°F

\*\*\*\*\*

2nd coat if necessary \*\*\*\*\* 2ND COAT: START

7:30 PM

TIME: 8:00 PM

OVEN TEMPERATURE: 400°F

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 09-09-15

①

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

51818

PPP 9/11/15 (X) C

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Item ID: D3172-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Base Assembly

Start Date: 09/04/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/15 *[Signature]**BL* 09-9-15

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# Picklist Print

September 3, 2009 2:32:33 PM

Work Order ID: 51814



Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	6.0000	2.00			
Clevis												

09/09/15

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse:

ST

6

31101

6

D2232-3RevC

Manufactured

No

100

Each

9.0000

2.0000



Basket Hinge

09/09/15

2009-09-11

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

2

50024

2

Main Warehouse

WA

7

50986

7

2009-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 51814



Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly


Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD  Spacer Bushing		Manufactured	No			100	Each	56.0000	2.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Premier

Mezz    46

44274    37

44365    9

Main Warehouse

ST    10

51126    10

② PD 09.09.09 ✓

D2581RevA1

Manufactured No

100

Each

37.0000

2.0000



Mounting Bracket

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    13

46086    2

48428    1

51120    10

Main Warehouse

WA    24

• 50872    24

2 Cpl 09-09-11 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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September 3, 2009 2:32:33 PM

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Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-1RevA1  Basket Hoop		Manufactured	No			100	Each	24.0000	4.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	24	
51248	12	
51474	12	

④ PD 09.09.08 ✓

D3174-1RevA1  Mounting Lug		Manufactured	No			100	Each	36.0000	8.0000			
----------------------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	36	
24882	6	
41632	30	

⑥ ② PD 09.09.08 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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September 3, 2009 2:32:33 PM

Work Order ID: 51814



Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	441.6589	48.0000			
Expanded Metal Flat SS												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT	441.6589065
108152	90
110134	6.7
110292	14.4
110629	14.41
110861	21.18
110992	0.58
111444	4.14
111630	9.15
111956	4.335517
112147	83.1447895
112311	193.6186

M304TS0.750W.065

Purchased

No

100

f

1,117.989

42.1053



304 SQ Tube .75x.75x.065W

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA	1117.98898
112344	117.98898
112398	1000

*460909.14 ✓*

*51.37 PD 09.09.09 ✓*

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

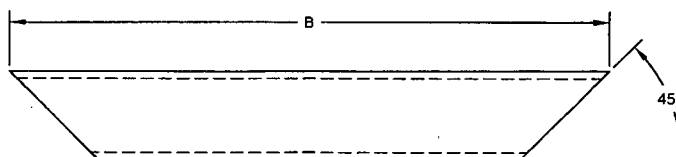
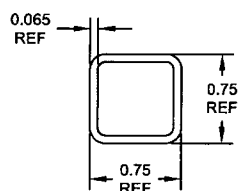
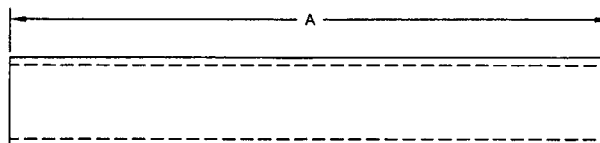
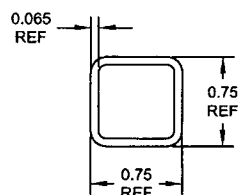
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# PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	A 2	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

# 51814  
MF  
09-09-03  
08.07.11



RELEASED  
08.07.11



## NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

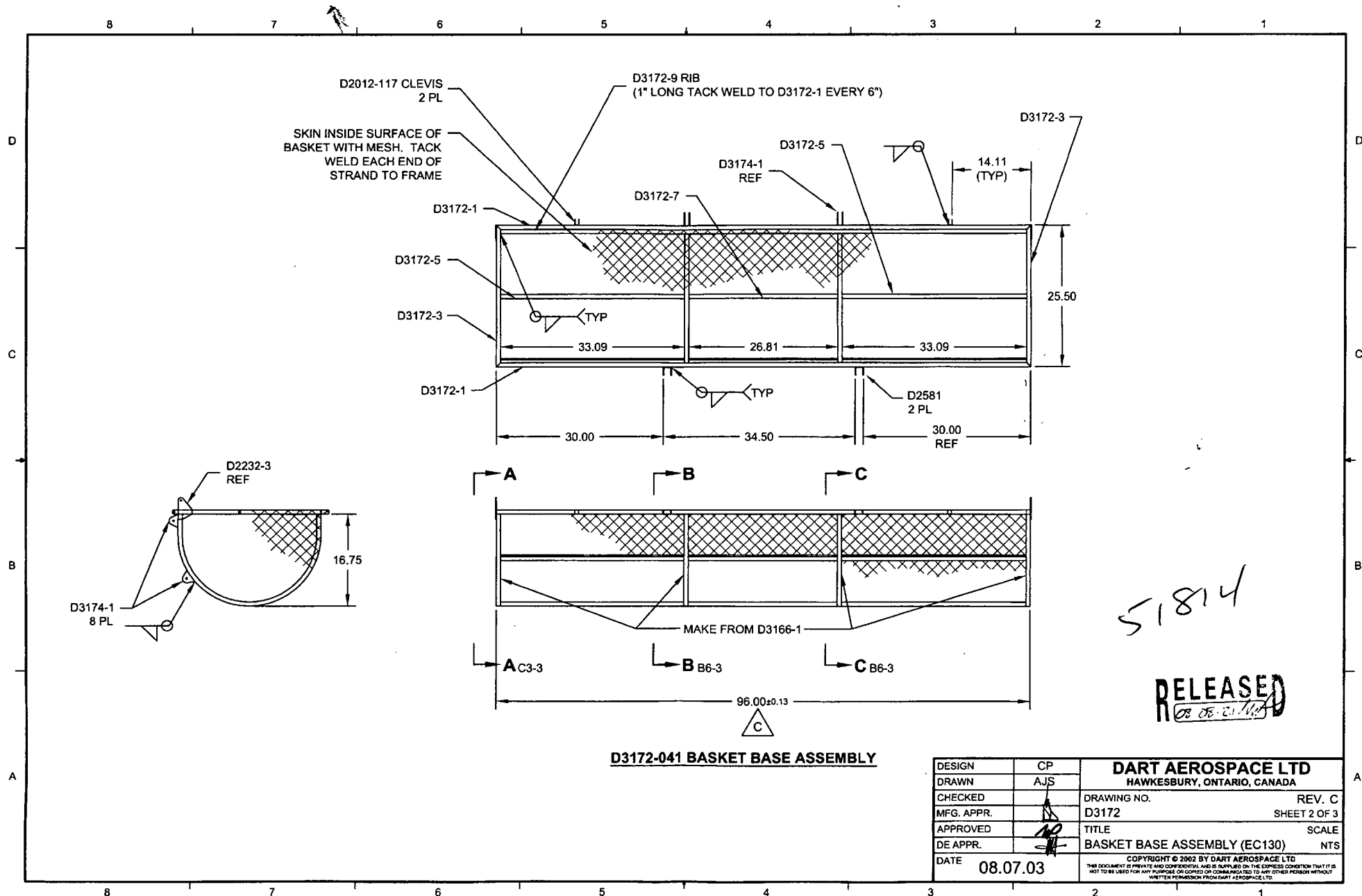
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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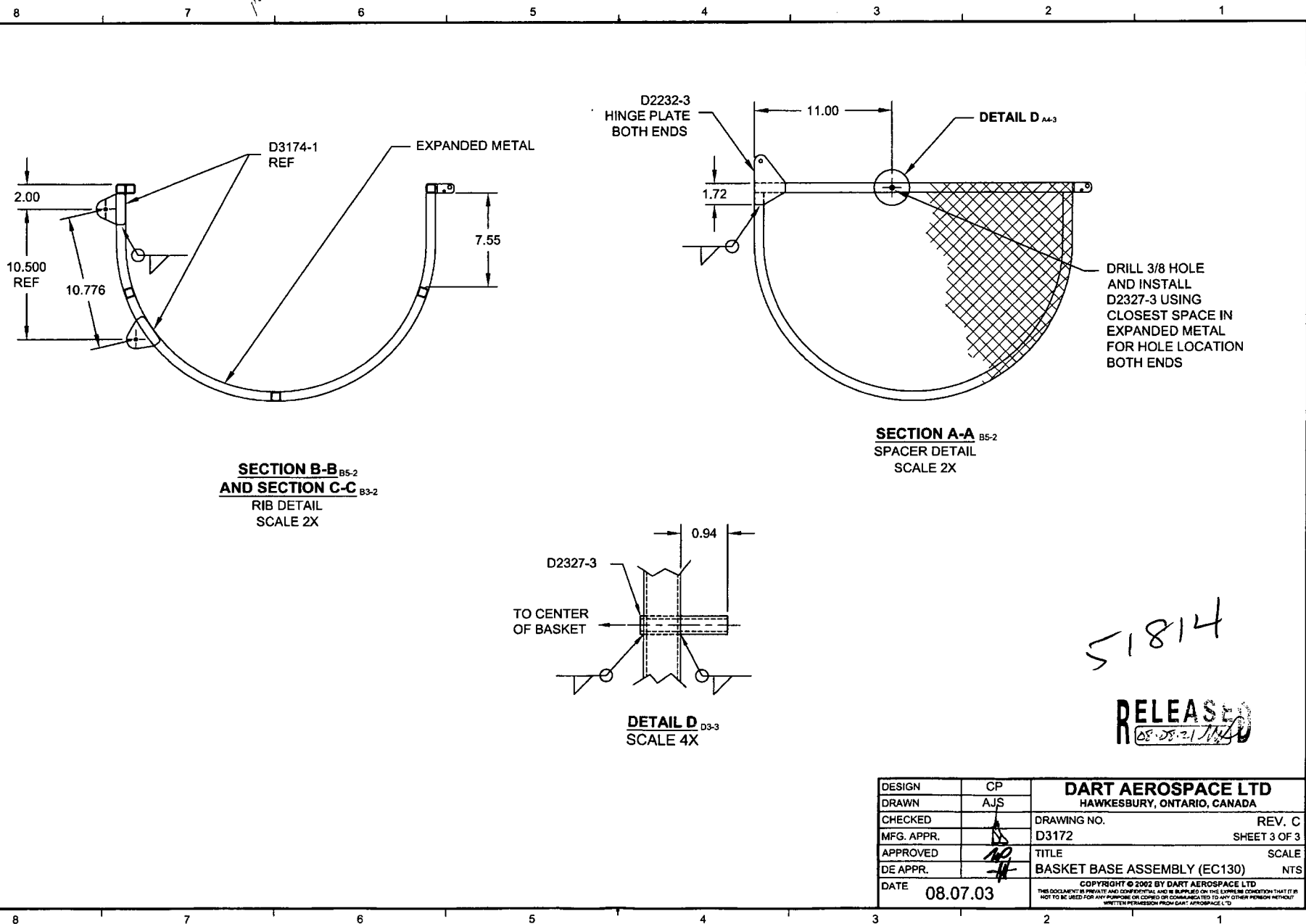
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